



Dart Aerospace Ltd.
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D3211-1
Job Sheet 185961



Part No: D3211-1

Job Qty: 4 ea

Part Name: Bracket For Interior Window For -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now on Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		11/28/18	0.00	0.86	Waterjet - Flow		se 18/11/18
120	QC	4 pcs		11/28/18	0.00	0.00	QC8		38
130	Small Fab	4 pcs		11/28/18	0.00	0.00	Small Fab-3		9-89
140	Brake NC	4 pcs		11/28/18	0.04	0.53	Brake NC 1		DAS
150	QC	4 pcs		11/28/18	0.00	0.00	QC5		DAS
160	HandFinish	4 pcs		11/28/18	0.00	0.21	HandFinish1		DEC 10 2018
170	Powdercoat	4 pcs		11/28/18	0.00	0.13	Powdercoat4		DR 18/10/10
180	QC	4 pcs		11/28/18	0.00	0.00	QC3		38
190	Packaging	4 pcs		11/28/18	0.00	0.00	Packaging3-1	5/438	9-89
200	QC21-SA	4 Ea		11/28/18	0.00	0.00	QC21		DEC 11 2018

Part Op 100 - 1-Cut as per Dwg D3211

Descriptions: 130 - Deburr

140 - Bend D3211-1 Stack as per Dwg D3211

170 - START TIME: 3:10 OUT: 3:40 FINISH: 3:40- M13889.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	5.6200 sf (1.405 ea)	100-Waterjet - Flow - 1	8066326
		9.032		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	6	115	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.250inches $\pm$ 0.030	0.280 0.220	0.252	
2	Bracket	1.910inches $\pm$ 0.030	1.940 1.880	1.913	
3	Bracket	0.128inches + 0.005 - 0.000	0.133 0.128	0.129	
4	Bracket	0.141inches	0.146	0.143	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	Against DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Date : _____					MRB (QSI042) Approval
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S128399 Part: D3211 - 1 Job No: 185961 Serial No/Batch: S128399 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 11/15/18					ion
					Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Environment Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	GORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
OTHER : _____					

		+ 0.005	0.141	
		- 0.000		
5	Bracket	17.710inches $\pm$ 0.030	17.740 17.680	17,710
6	Bracket	1.910inches $\pm$ 0.030	1.940 1.880	1,912
7	Bracket	1.560inches $\pm$ 0.030	1.590 1.530	1,564
8	Bracket	11.320inches $\pm$ 0.030	11.350 11.290	11,320

Plex 11/7/18 1:26 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								